

FAASA 119 Washers ASAP

Dart Aerospace Ltd.

Date: Tuesday, 2/26/2008 8:01:01 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 37619		
Estimate Number	: 12450		
P.O. Number	:	Part Number	: D351611
This Issue	: 2/26/2008 S.O. No. :	Drawing Number	: D3516 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31800	Material	:
Written By	:	Due Date	: 3/14/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>08 02 26</u>		
Comment	: Est Rev. A New Issue 06-06-09 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 .125 Sheet



Comment: Qty.: 0.0218 sf(s)/Unit Total : 0.4368 sf(s)

304/316 .125 Sheet 11GA

(M304S11GA)

Batch: 104934 IB 8-2-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3516

Dwg Rev: BProg Rev: B

2-Deburr if necessary

IB 8-2-27(30)08/03/03 (30)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-2-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/03/03(x20)counts

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3516

SB08/03/04(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 08/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:01:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 37619

Part Number: D351611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
08/23/06 (430)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

25 ST106

8/3/06 SD (30x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(30)
2008/03/07

Job Completion



mi 2008/3/07 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE N/A
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

RELEASED

06.11.28

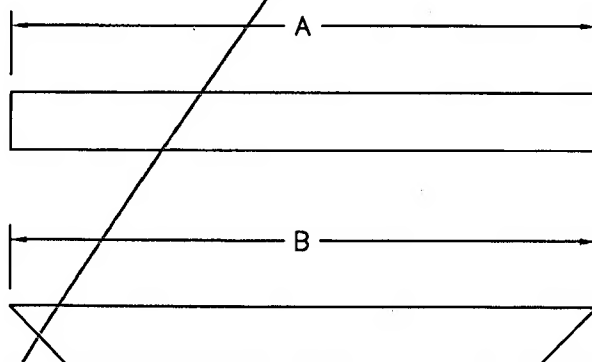
UNDER REVIEW

06.02.20

ADDITION OF HOOPS
& BUSHING PLATES**PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

B

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
(REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

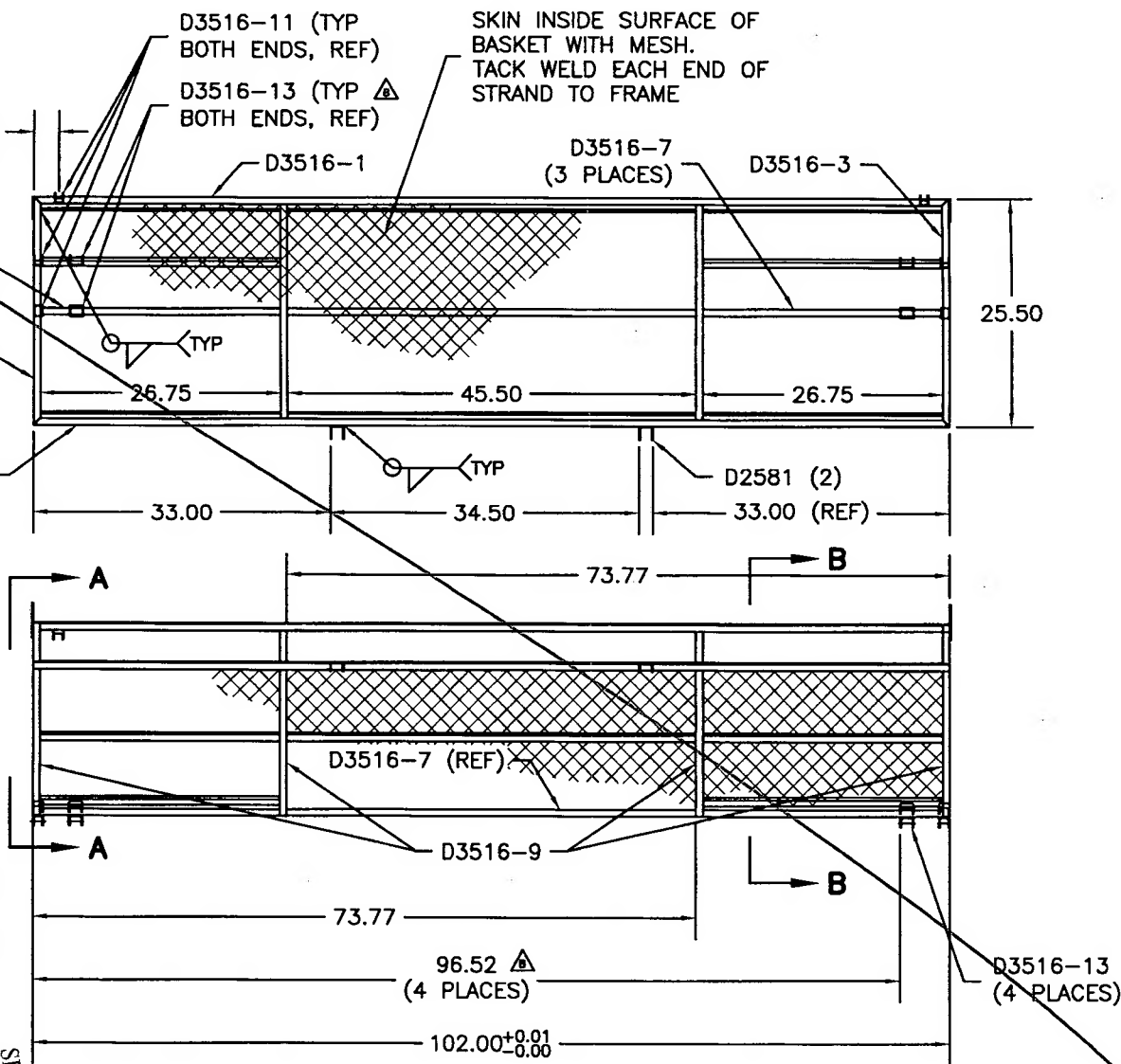
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DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	DRAWING NO. D3516	SHEET 2 OF 5
DATE 06.07.25	TITLE	BASKET BASE ASSEMBLY (A119)	SCALE 1:20



D3516-041 BASKET BASE ASSEMBLY

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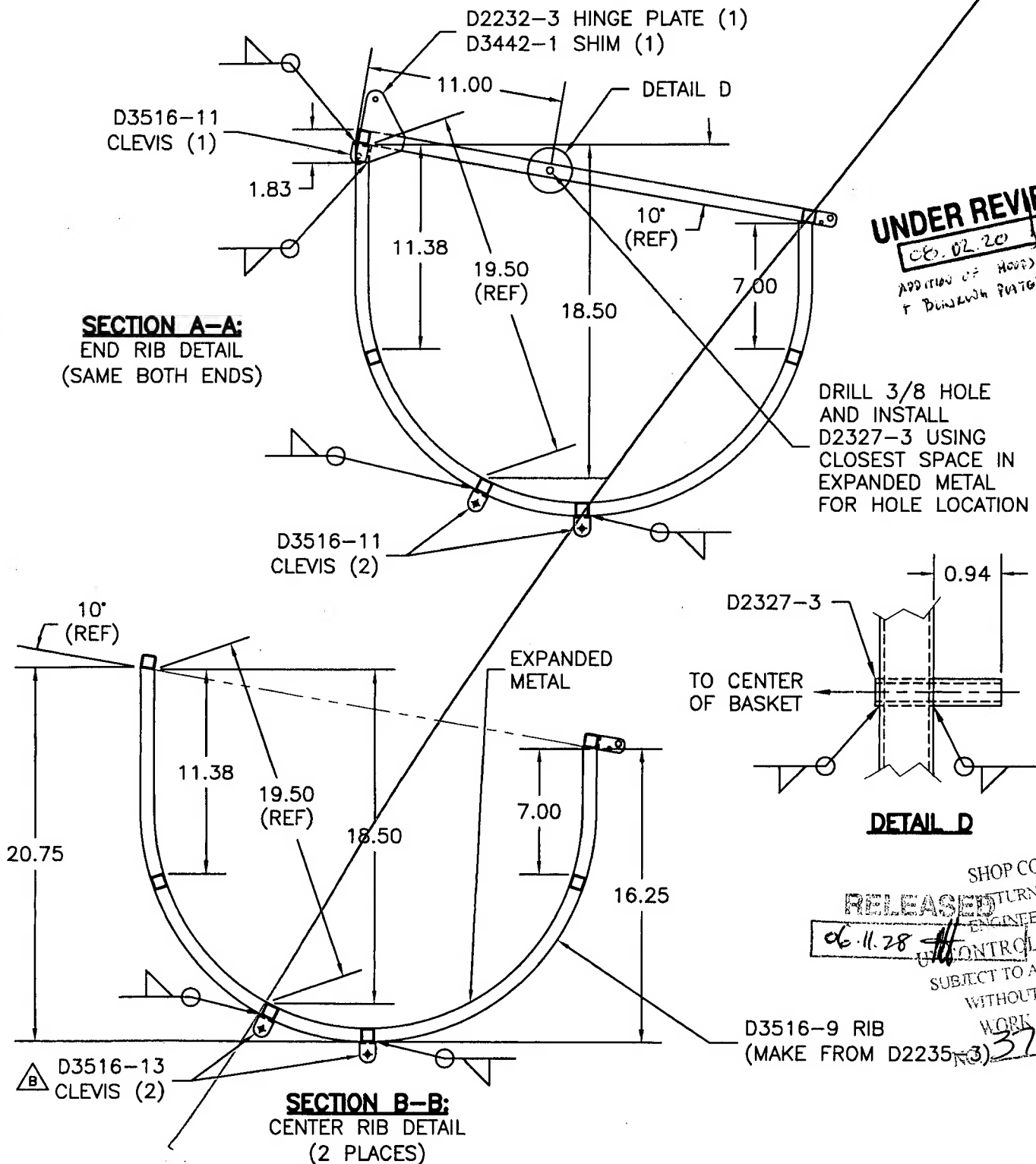
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UNDER REVIEW

06.07.20
APPROVED BY
T. BURRICH (A119)

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DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:8



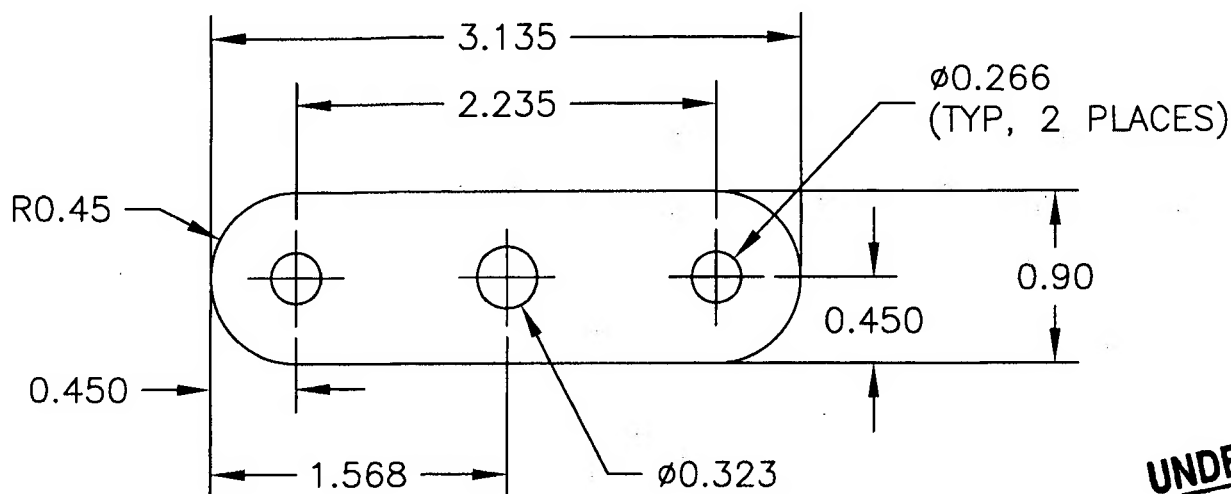
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DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:1

**UNDER REVIEW**06.02.20
ADDITION OF HOLES
& DIMENSION PAGES

OK PER REF. B

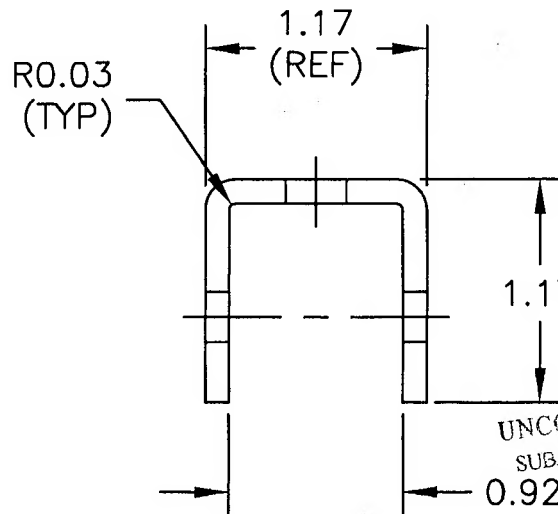
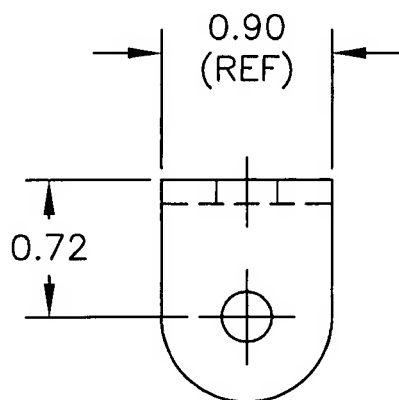
08.02.26

D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

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NO. 37619**D3516-11 CLEVIS BENDING DETAIL**

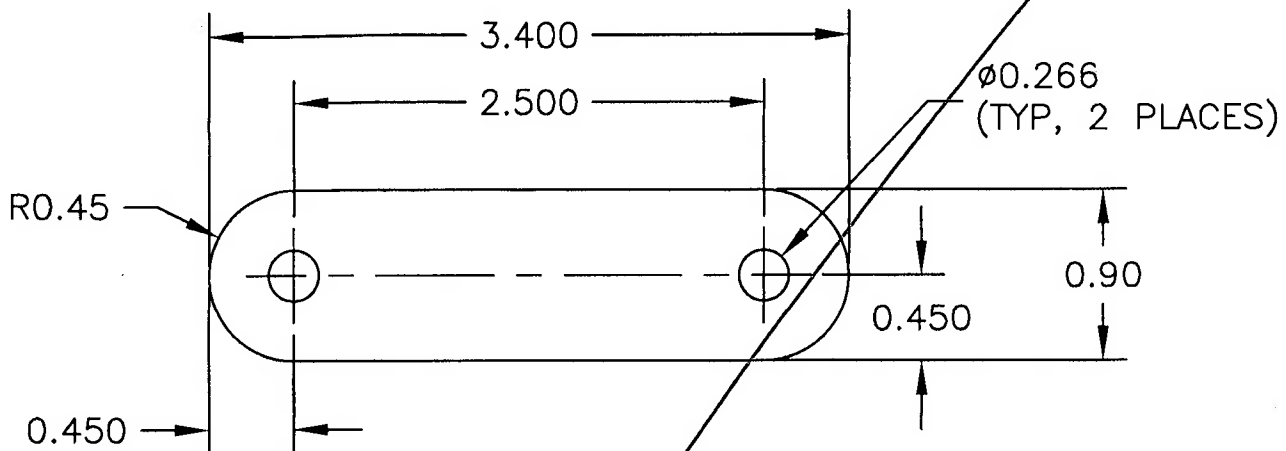
- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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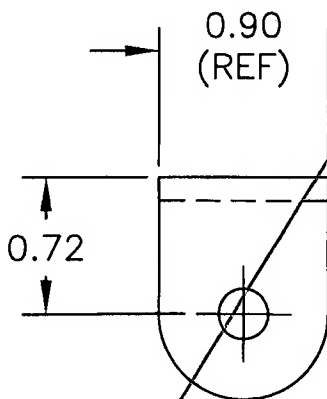
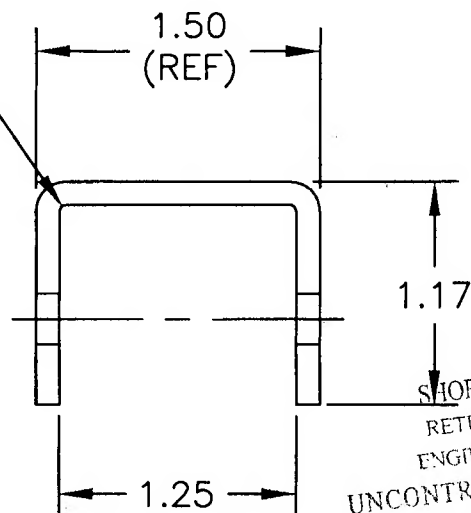
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 5 OF 5
DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:1

**D3516-13F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

**UNDER REVIEW**
CB. 02.20 *[Signature]*ADDITION OF HOLES
& BUSHING PATTERN**RELEASED**06.11.28 *[Signature]*

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D3516-13 CLEVIS BENDING DETAIL

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